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D4961-041
Job Sheet 202257



Part No: D4961-041

Job Qty: 6 pcs

Part Name: Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/19

Job Tracking No:

Due Date: 11/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 13.10.22 NEW ISSUE DD VERF:JFS IPP REV:B 15.02.18 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	6 pcs	11/6/19		0.00	3.57	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	6 pcs	11/6/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	6 pcs	11/6/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

SP 19-10-28.

DAS
40

ACT 3 1 2019 9-50

				Packaging 3 - 4 - B4B	ST 129	9-89
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
140	QC 21 - SA	6 pcs	11/6/19	0.00 0.00	QC 21 - SA - 21	DAS 21
					QC 21 - SA - 70	9-89
					QC 21 - SA - 53	

Part Op 110 - (Small Fab)

Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

NOV 18 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN818-L12J	Nut 325	12 Ea (2 ea)	110-Small Fab - 1	225282
M304TR0.750W.049	304 Round Tube .750 X .049W 002	4.2000 ft (.7 ea)	110-Small Fab - 1	205919
MS20819-12J	Sleeve 025	12 Ea (2 ea)	110-Small Fab - 1	142478x8 203497x4

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	AN818-L12J	12	14	0
	M304TR0.750W.049	4	95	0
	MS20819-12J	12	13	0

Part Specifications

Specifications could not be found.

Plex 10/25/19 11:16 AM dart.boucher.sylvie

Entered: _____

Date: _____

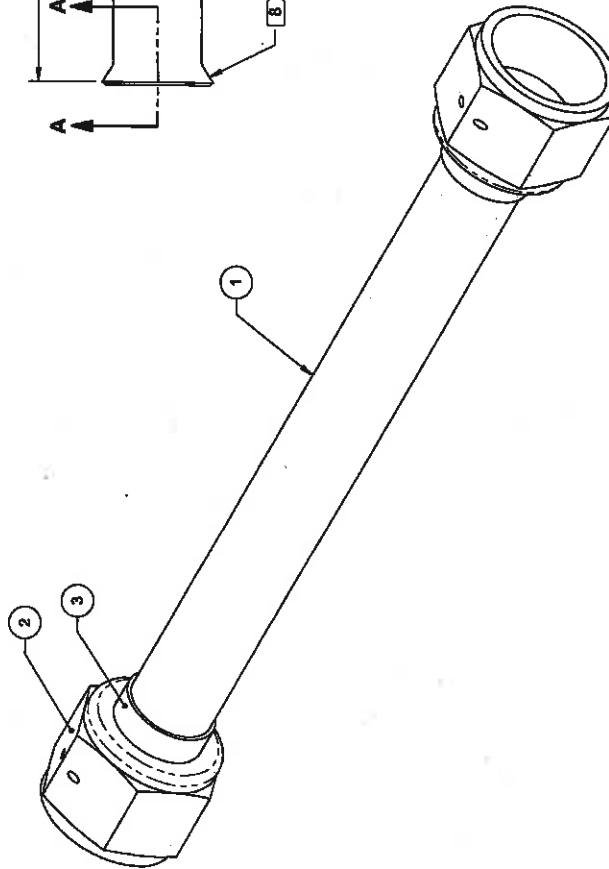
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐		MRB (QS1042)																													
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition																													
Description Work Order Deviation		Completed By																																	
		Lead hand / Supervisor																																	
		QC / QA Coordinator																																	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details:						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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ITEM	QTY	P/N	DESCRIPTION
	X	D4961-041	TUBE ASSEMBLY
1	1	D4961-1	TUBE
2	2	AN816-L12J	NUT, TUBE COUPLING (DRILLED)
3	2	MS20819-12J	SLEEVE



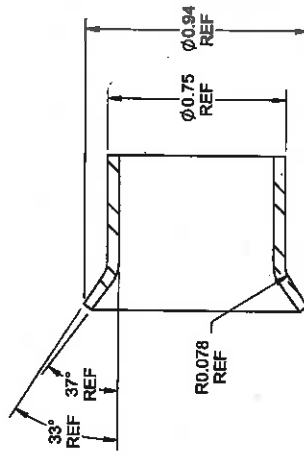
D4961-041 TUBE ASSEMBLY

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, $\phi 0.760 \times 0.049$ WALL PER ASTM A213 OR ASME SA213 OR ASTM A269 (REF DART SPEC M304TR)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.59 Lb
 - 8) FLARE TUBE PER MS33684
 - 9) CLEAN INSIDE OF TUBE AFTER FLARING ENDS

RELEASED
2016-08-07
Ecaj 16-622

APPROVED

D4961-1 TUBE



SECTION A-A

C	ADDED D4961-046 (SHEET 3)	CC	16.06.21
B	UPDATED BOM P/N AN816-L12J WAS AN816-L12J ADDED	AK	14.11.07
A	NEW ISSUE	VS	13.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	VS		
DRAWN	CC		
CHECKED	VS		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS		
DATE	16.06.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	D4961	REV. C
TITLE	TUBE ASSEMBLY	SHEET 1 OF 3
SCALE	NTS	

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